

HART'S "BUCKEYE" DIE STOCKS FOR PIPE

No. 23½, WITHOUT CUT-OFF

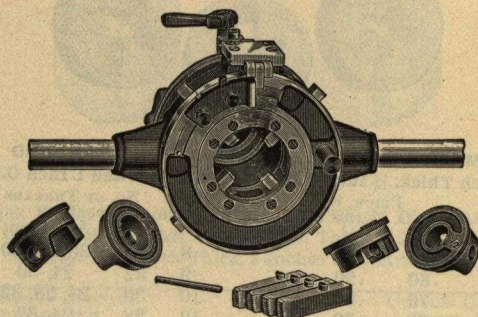


Fig. 6540A

The several distinctive features of these tools are best mentioned in detail.

DIES.—These are made to cut easily by being formed with a short cutting edge and by the automatically expanding movement which they have as they are screwed onto the pipe, and which renders it possible, with such short edges, to produce threads having the taper essential for making tight joints. These cutting edges are furthermore made so as to induce the dies to do their work without the aid of a leader screw. The remarkably small amount of power needed for such dies is explained mostly by the reduction of the friction generated in the case of dies with cutting edges of the usual length.

ADJUSTABILITY OF DIES.—The dies themselves, and the stock are so constructed that a wide range of diameters is covered by one set of dies, a single set being used for 1, 1¼, 1½ and 2-inch pipe, for instance, thus avoiding changes and the care of additional parts.

AUTOMATIC RELEASE OF DIES.—As soon as the dies have been screwed onto the pipe far enough to complete a thread, they stop cutting and release themselves, permitting the immediate removal of a tool from its work.

DIE LEADING DEVICE.—Instead of a leader screw, ordinarily used with the narrow, expanding style of dies, there is a leader ring which automatically causes the dies to start without any hand pressure, and through its employment the thread cutting that a tool is capable of doing, is not limited simply to threads of the same number to the inch, as are on a leader screw, nor to one direction of lead, making it possible to also thread either right or left-handed. There is no reversing of the dies to be done with this device, nor screwing apart of pieces. Its life is many times greater than a leader screw.

Nos. 25, 26 and 26½ are provided with gears which, with the aid of a ratchet wrench, enable all the work to be done by one man, the same as with the smaller sizes. Nos. 24, 28 and 28½ are of a ratchet pattern, especially adapted to work in close quarters.

Number	Pipe Threading Sizes Inches	Number of Sets of Dies	PRICE, EACH		Price, Extra Dies per Single Set
			Without Cut-Off	With Cut-Off	
23	1, 1¼, 1½, 2	1	30.00	35.00	5.50
23½	½, ¾, 1, 1¼, 1½, 2	2	35.00	40.00	5.50
24	1½, 2, 2½, 3	2	80.00	88.00	9.00
25	2½, 3, 3½, 4	1	115.00	125.00	9.00
26	4½, 5, 6	1	220.00	235.00	16.00
26½	2½, 3, 3½, 4, 4½, 5, 6	2	240.00	255.00	16.00
28	1, 1¼, 1½, 2	1	36.00	41.00	5.50
28½	½, ¾, 1, 1¼, 1½, 2	2	41.00	46.00	5.50

Dies for Nos. 23, 23½, 24, 25, 28, and 28½ have four pieces to the set. Those for Nos. 26 and 26½ have six pieces.

HART'S DUPLEX DIE STOCKS

Nos. 41 TO 49

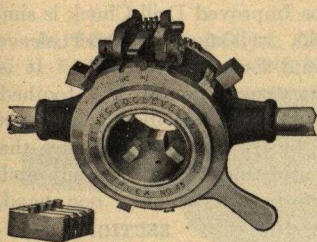


Fig. 3394A

These tools are fitted with adjustable dies and guide or centering jaws. What may be spoken of as the distinguishing features between them and other similar tools, are the means for setting the dies to size, for holding the dies in position, and releasing them at the end of a cut. The setting is done with great accuracy and by simply using the hand. The holding does not depend on any frictional clamps, screws or nuts, but on a positive lock. The releasing is accomplished instantly and avoids turning back.

The dies are of the chaser form, the most readily adjusted and sharpened. They do their work while held stationary. Quick adjustment enables the operator to at once alter size of threads, so as to suit any variation in pipe fittings.

The guide jaws center the pipe accurately to the dies; they are adjusted simultaneously to all sizes of pipe. The mechanism for accomplishing it is self-locking, and its adjustment cannot be accidentally disturbed.

The cutting-off device, as has been customary, is also furnished in the equipment of the tools, unless its omission be specified. It cuts the pipe squarely and cleanly.

No.	Threads, Pipe, Inches	PRICE, EACH		EXTRA DIES			Price, Extra Cutting-Off Tools Each
		Without Cut-Off	With Cut-Off	Price Complete Set	Single Sets in Complete Set	Price of Single Set (4 Pieces)	
41	$\frac{1}{4}$, $\frac{3}{8}$, $\frac{1}{2}$, $\frac{3}{4}$	12.00	15.00	5.20	2	2.60	.75
41½	$\frac{1}{8}$, $\frac{1}{4}$, $\frac{3}{8}$, $\frac{1}{2}$, $\frac{3}{4}$	14.00	17.00	7.80	3	2.60	.75
42	$\frac{1}{2}$, $\frac{3}{4}$, 1, 1¼	15.50	18.50	6.20	2	3.10	.75
42½	$\frac{1}{4}$, $\frac{3}{8}$, $\frac{1}{2}$, $\frac{3}{4}$, 1, 1¼	17.00	20.00	9.30	3	3.10	.75
43	1, 1¼, 1½, 2	22.00	25.00	7.40	2	3.70	.75
43½	$\frac{1}{2}$, $\frac{3}{4}$, 1, 1¼, 1½, 2	25.00	28.00	11.10	3	3.70	.75
44	1½, 2, 2½, 3	40.00	45.00	13.00	2	6.50	.90
45	2½, 3, 3½, 4	55.00	60.00	15.00	2	7.50	.90
*47	$\frac{1}{2}$, $\frac{3}{4}$, 1, 1¼	18.50	21.50	6.20	2	3.10	.75
*47½	$\frac{1}{4}$, $\frac{3}{8}$, $\frac{1}{2}$, $\frac{3}{4}$, 1, 1¼	20.00	23.00	9.30	3	3.10	.75
*48	1, 1¼, 1½, 2	25.00	28.00	7.40	2	3.70	.75
*48½	$\frac{1}{2}$, $\frac{3}{4}$, 1, 1¼, 1½, 2	28.00	31.00	11.10	3	3.70	.75
*49	2½, 3, 3½, 4	60.00	65.00	15.00	2	7.50	.90

*Ratchet pattern.

Nos. 51 TO 52½

These particular sizes of tools are constructed like the Nos. 41 to 45, but for some ranges of diameters they are fitted with dies of the double-ended form, each end of which is capable of threading two diameters. With a single set of such dies, therefore, it is possible to cut threads on four different diameters of pipe, and this makes the tools especially suited to certain classes of work that necessitate their being carried about considerably.

Extra dies per set (four pieces), Nos. 51 and 51½: ⅛-inch, single-ended, 2.60; ¼ to ¾-inch, double-ended, 5.20. Nos. 52 and 52½: ¼ and ⅜-inch, single-ended, 3.10; ½ to 1¼-inch, double-ended, 6.20.

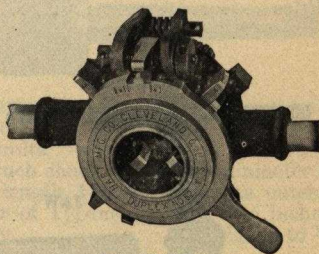


Fig. 3394B

Number	Threads Pipe Inches	PRICE, EACH	
		Without Cut-Off	With Cut-Off
51	$\frac{1}{4}$, $\frac{3}{8}$, $\frac{1}{2}$, $\frac{3}{4}$	12.00	15.00
51½	$\frac{1}{8}$, $\frac{1}{4}$, $\frac{3}{8}$, $\frac{1}{2}$, $\frac{3}{4}$	14.00	17.00
52	$\frac{1}{2}$, $\frac{3}{4}$, 1, 1¼	15.50	18.50
52½	$\frac{1}{4}$, $\frac{3}{8}$, $\frac{1}{2}$, $\frac{3}{4}$, 1, 1¼	17.00	20.00